Bloch Smiller

V	V۵	rk	Order	ID '	1021	ng
v	V (11 K	vi uci	IV.	IUZI	ロリフ

Work Orde <i>May-27-13</i> 8:46		2109	*102109*								Page	1
Item ID: Revision ID:	D3913-041 y			Accept	*N900	040	100)* s	etup Star	*N	S1*	
	Long Basket E	Base Assemby, 350							Sto	*N	S2*	
Start Date:	5/27/13	Start Qty: 1.00	*1*		Cust Item I	D:						
Required Date:	6/05/13	Req'd Qty: 1.00	*1*		Customer:							
Reference:							_	_				
Approvals:	Process Pla	n: <u> </u>	Date:	Tooling:	Da	ate:	MP	н	tun Star	<i>"IV</i>	R1*	
	QC:		Date:	SPC (Y/N):	Da	ate:			Sto	*N	R2*	
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject ¹ Number	Insp. Stamp	
Draw Nbr	Rev	ision Nbr										
D3913	В											
D4020	Α											
*100 *100* Large Fab Large Fab		Large Fab Memo I- assemble ***inspect	ribs, weld as per dwg D before welding mesh***	0.00 3913 using DT9610A	GC13.	6*4		_lx_				-
		and trim me	20-1 base mesh and tack wesh to fit if necessary and	rim to clear fasteners hole							•	
		3- weld hin ***take lid	ge (3) and Mounting brack to locate hinge and brack	kets as per dwg D3913 et***							C	:*
		4- Weld D4	672-1 blanking plates as p	per dwg						, A.	DA	S
*110		QC9- Inspect visual per	QSI004- Fusion Welds	0.00				in	3-06-i	501	Og 8	1
QC		Memo		0.00					J- 06-(ر ب		

NCR: Y	'es	/ No				WORK ORDER NON-C	CON	IFORN	MANCE / UPE	DATE	04.61	Data	# ^
						T			· · · · · · · · · · · · · · · · · · ·	 	QA Closed:	······································	
Work Orde	r:					DISPOSITION	1			AGAINST DE	PARTMENT	/PROCESS	
	-					Rework	1		Skid-tube	Crosstube]	Water Jet	Engineering
Part N	lo.					Scrap]	ľ	Machining	Small Fab	4	d. Eng. Coor.	Quality
_						Use-as-is	1		noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	lo.					Work Order Update	┚┃		Large Fab	Composite	J	Supplier	
Root					Descri	ption of work order update	İr	nitial	Acti	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chi	ief Eng	Descri	iption	Date	Verification	QC Inspector
oc/Data	_												
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perator	4												
//aterial	-												
etup									1			*	
Other	\dashv												
rocess	\dashv												
upplier raining	\dashv												
Inapproved													
ларрготса			<u> </u>	i			AUL	T CATE	GORY		.1		
Landir	ng G	iear				General						A. T.	
	_	Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld
		Crushed/0	Crimped			Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance	<u></u>	Part Moved		
٠, ١		Heat Trea	t			Countersink	Ш	Mislabe	led		Positioned V	Vrong	 -
હ ્		Inspection	n Strip in	Tube		Cut Too Short		Misread	i	L.	Power Loss/	Surge	Other
		Ripples in				Drill Holes	-	Offset					
;		Torque W	aves in E	xtrusio	ւ 📙	Drawing		Out of C	Calibration				
	Torque Waves in Extrusion Turning Sequence			Finish		Out of S	equence						

Outside Dimensions

Date:

DQA:

Wave/Twist in Tube

Folio

Work Ord <i>May-27-13 8:</i>		02109		*102		Pa					
Item ID: Revision ID:	D3913-041	l		Accept	*N900	040	100)* 5	Setup Star	*N	S1*
Item Name:	•								Sto	*N	S2*
Start Date: Required Dat	5/27/13 ee: 6/05/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					
Reference:											
Approvals:	Process P	Plan:	Date:	Tooling:	Da	ate:	_	F	Run Stai	17	R1*
	QC:		Date:	_ SPC (Y/N):	Da	ate:			Sto	*N	R2*
Sequence ID/ Work Center		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*120 *120*		QC5- Inspect part comp	leteness to step on W/O	0.00				13	-060°	\	0AS)
QC				0.00							3-89 /

125

Pressure Wash per QSI005 4.3

Memo

0.00

125
HandFinish

Hand Finishing

Quality Control

Memo

0.00

Page 2

NCR:	Yes	/	No

DQA:

Date:

NCR: Y	es / No				WORK ORDER NON-C	CONFORI	MANCE / UP	DATE	QA Closed:	Date:		
							· · · · · · · · · · · · · · · · · · ·	<u></u>	QA Closed.	Date	•	
Work Orde	j.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS		
WOIK OIGE					Rework		Skid-tube	Crosstube		Water Jet	Engineering	
Part N	Ο.				Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
	··		÷		Use-as-is	1 1	noforming	Finishing	-4	re/Packaging	Other	
NCR N	Ο.				Work Order Update		Large Fab	Composite	1	Supplier	1	
			,		· <u>L</u>	'		•				
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector	
oc/Data		ļ									,	
quip/Tooling	_											
perator												
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etup								•				
Other												
rocess							1					
Supplier									ļ			
raining												
Inapproved							<u> </u>					
		 			F	AULT CATE	GORY					
Landin	g Gear				General	_		_	7	_	, ·	
<u> </u>	Bending				Bend	Grain		_	Ovalized	<u> </u>	Pressure/Forced	
	Centre No	ot Concer	ntric to (D/S	BOM/Route	Hardwa	are		Over/Under	⊢	Temperature/Cure	
ļ	Cracks			<u> </u>	Broken/Damaged	Inspect	ion Incomplete	<u> </u>	Part Incorred	ct	Weld	
	Crushed/	Crimped			Burrs	Instruc	tions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
Į	Cuffs				Contamination	Mainte	enance	· L	Part Moved			
. [Heat Trea	at .			Countersink	Mislabe	eled	L	Positioned V	Vrong		
	Inspectio	n Strip in	Tube		Cut Too Short	Misrea	d		Power Loss/	Surge	Other	
<u>,</u> ,e	Ripples in	Bend			Drill Holes	Offset						
	Torque W	Vaves in E	xtrusior	1	Drawing	Out of	Calibration					
Ţ	Turning S	equence			Finish	Out of	Sequence					
Ī	Wave/Tw	ist in Tub	oe .		Folio	Outside	Dimensions					

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Work Ordo <i>May-27-13 8:46</i>		2109	•	*102109*								Page 3
Item ID: Revision ID: Item Name:	vision ID:			Accept	*N900	040	100)*	Setup	Start Stop	*NS	•
Start Date: Required Date: Reference:	5/27/13 6/05/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:		an:		Tooling: SPC (Y/N):		ate:			Run	Start Stop	*NR *NR	_
Sequence ID/ Work Center II 130 *130* Powdercoat Powder Coating		BLACK SA IST COAT: START TIM OVEN TEM FINISH TIM ********** 2ND COAT START TIM OVEN TEM	as and mask only interior of NDTEX ME: ME: ME: ME: ME: ME: ME: M	Set Up/ Run Hours 0.00 0.00 of hinge (3) prior to powder of the second		Tool#	Plan Code	Accep Qty	Qt	y N		sp. amp
140 *140* QC		QC3- Inspect Part Finish	ı ·	0.00					4	/ 2 /3	3.65	. 334V

Memo

140

Quality Control

NCR: Y	es / N	0			WORK ORDER NON-	COI	NFORI	MANCE / UPD	DATE			
					<u> </u>	-		·		QA Closed:	Date:	
Work Orde	ŕ:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N	0.				Rework Scrap			Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
	·				Use-as-is	1		noforming	Finishing	4	e/Packaging	Other
NCR N	o				Work Order Update]		Large Fab	Composite]	Supplier	
Root				Descr	iption of work order update		Initial	Acti	ion	Sign &		
Cause	Dat	e Step	Qty		or Non-conformance	Ch	nief Eng	Descri	iption	Date	Verification	QC Inspector
oc/Data												
quip/Tooling						1						
perator		1										
/laterial	_						•					
etup								,		*		i
Other			1									
rocess			Ì									
upplier		Ì										
raining		į			-							
Inapproved					<u>.</u>	L						
					F	AUL	T CATE	GORY				
Landin	g Gear				General		-			_		_
L	Bendi	ng		L	Bend		Grain			Ovalized		Pressure/Forced
. [Centr	Not Conce	entric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Crack	5			Broken/Damaged		Inspect	on Incomplete		Part Incorred	t	Weld
	Crush	ed/Crimped	d .		Burrs		Instruct	ions Incomplete/U	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	. Cuffs				Contamination		Mainte	enance		Part Moved		
· • [Heat	reat			Countersink		Mislabe	eled		Positioned W	/rong	_
• [Inspe	tion Strip i	n Tube		Cut Too Short		Misread	t		Power Loss/	Surge	Other
Ī	Ripple	s in Bend			Drill Holes		Offset					
Ī	Torqu	e Waves in	Extrusio	n	Drawing		Out of 0	Calibration				,
Ţ	Turni	ng Sequenc	e		Finish		Out of 9	Sequence				
Ī	Wave	/Twist in Tu	ıbe		Folio		Outside	Dimensions				-

DQA:

Date:

					•		•		
	Work Order ID 102109 May-27-13 8:46:29 AM			*102			Page 4		
Item ID: Revision ID: Item Name:	D3913-041 Long Basket	Base Assemby, 350		Accept	*N900040	100)* Se	etup Star Sto	111.7
Start Date: Required Date Reference:	5/27/13 : 6/05/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:				
Approvals:	Process Pl	ań:	Date:	Tooling:	Date:		R	un Sta	"NRT"
	QC:		Date:	_ SPC (Y/N):	Date:			Sto	*NR2*
Sequence ID/ Work Center I 150 *150* HandFinish Hand Finishing	D	Operation Description Assemble as per dwg Memo Pick Kit		Set Up/ Run Hours 0.00	Tool ID Tool #	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
160 *160* QC Quality Control	·	QC5- Inspect part compl Memo	leteness to step on W/O	0.00 Sm 0.00		·	<u></u>		· · · · · · · · · · · · · · · · · · ·

170

Identify as per dwg & Stock Location 14030-066

102/06

170

Packaging

Memo

0.00

1 \$ H18-6-5.

Packaging

			DQA:	Date:
NCR: Yes	No N	WORK ORDER NON-CONFORMANCE /	UPDATE	

										QA Closed:	Dat	te:
Work Orde	er:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap Use-as-is Work Order Update		ا Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Quality Other
Root				Descri	iption of work order update	lni	itial	Act	tion	Sign &		
Cause	Da	ite Step	Qty		or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	n QC Inspector
Doc/Data					· · · · · · · · · · · · · · · · · · ·							
Equip/Tooling				1							i	
Operator]						
Material		Ì										
Setup												
Other				[
Process				ļ								İ
Supplier	Ш										·	
Training												
Unapproved			1							ļ		
						AULT	CATE	GORY				
Landi	ng Gear			<u></u>	General				<u></u>	٦	Г	 1
	Bend	-			Bend	\vdash	irain		<u> </u>	Ovalized		Pressure/Forced
	_	re Not Conce	ntric to	o/s _	BOM/Route	-	ardwa			Over/Under	•	Temperature/Cure
	Crac			<u> </u>	Broken/Damaged	_		on Incomplete		Part Incorred	}	Weld
	_	hed/Crimped		<u> </u>	Burrs	-		ions Incomplete/	Unclear	Part Lost/Mi	ssing [Wrong Stock Pulled
	Cuffs		<u> </u>	Contamination	\vdash		nance	<u> </u>	Part Moved			
	Heat Treat			ļ	Countersink	\vdash	1islabe		<u> </u>	Positioned V	Ŭ r	г 1
	Inspection Strip in Tube			Cut Too Short	\blacksquare	/lisread		L.	Power Loss/	Surge [Other	
		les in Bend		<u> </u>	Drill Holes	\vdash	ffset					
	_	ue Waves in		n	Drawing	\vdash		Calibration				
	_	ing Sequence		<u> </u>	Finish	\mathbf{H}		equence				
Wave/Twist in Tube		Folio		utside	Dimensions							

Work Ord May-27-13 8:4		02109					Page					
Item ID: Revision ID: Item Name:	D3913-04 Long Baske	t Base Assemby, 350		Accept	*N900	040	100)* 5	Setup St St	_	NS1 NS2	
Start Date: Required Date Reference:	5/27/13 e: 6/05/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:	Process F	Plan:	Date:	Tooling:	Da	ate:	_	Ī	Run St	art 🛧	NR1	*
	QC:		Date:	SPC (Y/N):	Da	ate:			St	op *	NR2	*
Sequence ID/ Work Center	ID	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Rejec Num		
180 QC Quality Control		Memo		0.00				MC	.5	-,	16-06 Mr 13-6	05

NCR:	Yes	/	No

NCR: Ye	R: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE											
										QA Closed:	Date:	
Work Order	:				DISPOSITION		- · · · · -		AGAINST D	EPARTMENT,	/PROCESS	
Part No	o				Rework Scrap	}	· f	Engineering Quality				
NCR No	o				Use-as-is Work Order Update		Therm	Other .				
Root				Descr	iption of work order update	ln	itial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Descr	ription	Date	Verification	QC Inspector
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Other	_											·
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Inapproved		<u> </u>		<u> </u>		1	CATE	CORV		<u> </u>		L
·						AULI	CATE	JURY				
Landin				Г	General Bend	\Box	Grain			Ovalized		Pressure/Forced
-	Bending Centre N	-t C		~,	BOM/Route	\mathbf{H}			-	Over/Under	toloranco	Temperature/Cure
-	Cracks	or Conce	ntric to	^{0/3} -	Broken/Damaged	\vdash	lardwa nenesti	re on Incomplete	<u> </u>	Part Incorred		Weld
-	Crushed/	Crimnad		<u> </u>	Burrs	\vdash	•	ions Incomplete/L	Inclose	Part Lost/Mi		Wrong Stock Pulled
-	Cuffs	Crimped		-	Contamination	_	Mainte	•	- Inclear	Part Moved	221118	I MALOUR STOCK Laused
-	Heat Trea	••		-	Countersink	-	viainte Mislabe		_	Positioned V	Vrong	
}	Inspectio		Tubo	 	Cut Too Short	-	viisiabe Misreac		-	Power Loss/		Other
-	Ripples ir		iune		Drill Holes	\longrightarrow	viisread Offset	ı	L	Trower ross/	ouige	Other
<u> </u>	Torque V		- - - - -	<u>,</u>	Drawing	$\boldsymbol{\vdash}$		Calibration			· · · · · · · · · · · · · · · · · · ·	
F	Turning S			" ├	Finish	\mathbf{H}		equence				
-	Wave/Tw	-		-	Folio			Dimensions				
	I ARGAC' I A	rist iii iul	J.		ין טווט	1 1	Juisiue	Difficiations				

DQA:

Date:

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Work Order ID:

102109

Parent Item:

D3913-041

Parent Item Name:

Long Basket Base Assemby, 350

Start Date: 5/27/13

Required Date: 6/05/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC

verified by:EC IPP REV:C 12.07

03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total. Qty	Qty Issued	Date Issued	Status
AN3-10A Bolt		Purchased	No			150	Each	563.0000	6	6	BL	13-6	<u>::5.</u>
				Location		Loc Oty	<u>1</u>	oc Code					
				GA		16							
				12	22800	16							
				ST351		4							
		•		12	24221	3		-					
				12	24858	1							
				ST512	. ,	43							
				12	22800	43							
				ST513		500			`				
				m	125709	500							
AN960JD8 Washer	NAS1149DN832J	Purchased	No		125268.	150	Each	0.0000	2	2^{2}	B4	13-6	5-5
D2581 Mounting Bracket		Manufactured	No			100	Each	60.0000	2	2	CX13.0	5.4	
J				Location		Loc Oty	<u>I</u>	oc Code	Ē	3990	67 —	- (E
				WA		6							
				98	8503	6							
•				WA004		54							
					01383	20							
					0766	2							
					1253	1							
					2506 3230	2							
					5452	2			-				
					7706	2							

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99067

99837

											DQA:	Date	:
NCR:	⁄es	/ No				WORK ORDER NON-C	100	NFORM	MANCE / UP	DATE			
											QA Closed:	Date	:
Work Orde	sr.				:	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
	- . No.					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
1 4		· · · · · · · · · · · · · · · · · · ·					AUL	T CATE	JORY				
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspection Ripples in	ot Concer Crimped at n Strip in		· —	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes			on Incomplete ions Incomplete/ nance led	'Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Torque W	aves in E	xtrusio	n	Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

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Work Order ID:	102109							
Parent Item:	D3913-041					Start D	ate: 5/27/13	Required Date: 6/05/13
Parent Item Name:	Long Basket Base Assemby, 350					Start (Qty: 1.00	Required Qty: 1.00
D2931 Bumper	Manufactured	No		150	Each	2,188.0000	2	2 BR 13-6-5.
			Location	Loc Qty		Loc Code		
			GA /	190				_
			46064 🗸	190				_
			ST021	1998				
			86435	1998			-	
D3913-1	Manufactured	No		100	Each	5.0000	1	$\frac{1}{3}$ $\frac{(p(3.6.4))}{397735} = (1)$
Rib								25777
			Location	Loc Qty		Loc Code	-	3 1 1 1 3 3 (1)
			WA004	4				
			94721	4				_
			WA005	1				_
			88637	1				
D3913-15	Manufactured	No		100	Each	15.0000	1	1 /0(12/24
Wide Handle Plate								B100417-
			Location	Loc Qty		Loc Code		D100417->-(1)
			WA003	10				_
			100417	10				_
			WA004	5				
			97719	5				
D3913-3	Manufactured	No		100	Each	5.0000	1	B100444-1
Rib						•		75.6.7
			Location	Loc Qty		Loc Code		B100444(1)
			WA004	. 3				-
			97728	2				_
			97973	1			-	_
			WA005	. 2				_
			69160	1				_
			84651	1				_

											DQA:	Date:		
NCR: Yes	No No	WORK ORDER NON-CONFORMANCE / UPDATE									QA Closed:	Date:		
Work Order:					DISPOSITION					AGAINST DE	PARTMENT	/PROCESS		
					Rework]		Skid-tube]	Crosstube		Water Jet	Engineering	
Part No.	,				Scrap		1	Machining		Small Fab	Pro	d. Eng. Coor.	Quality	
					Use-as-is	1	Thern	noforming		Finishing	Rec/Sto	re/Packaging	Other	
NCR No.					Work Order Update			Large Fab]	Composite	,	Supplier] [_
		,									I -: -	<u></u>	1	
Root	1	ļ			ption of work order update	1	Initial		4ctio		Sign &			
Cause	Date	Step	Qty	. (or Non-conformance	Ch	nief Eng	Des	scrip	otion	Date	Verification	QC Inspect	or
Doc/Data				ļ										
Equip/Tooling												}		
Operator _	, -													
Material														

FAULT CATEGORY Landing Gear General Bend Grain Ovalized Pressure/Forced Bending Centre Not Concentric to O/S BOM/Route Over/Under tolerance Temperature/Cure Hardware Weld Broken/Damaged Part Incorrect Cracks Inspection Incomplete Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped Burrs Part Moved Cuffs Contamination Maintenance Positioned Wrong Countersink Mislabeled Heat Treat Other Inspection Strip in Tube Misread Power Loss/Surge Cut Too Short Ripples in Bend Drill Holes Offset Drawing Out of Calibration Torque Waves in Extrusion Finish Out of Sequence Turning Sequence

Outside Dimensions

Wave/Twist in Tube

Folio

Setup Other Process Supplier Training Unapproved

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102109			*					
D3913-041			•		•	Start	Date: 5/27/13	Required Date: 6/05/13
Long Basket Base A	assemby, 350					Start	Qty: 1.00	Required Qty: 1.00
	Manufactured	No		100	Each	2.0000	2	2 CpC13.6.4
			Location	Loc Qty		Loc Code		B100484->
			WA004	i				,
			94742	1	4			•
			WA006	1				
				1				
	Manufactured	No		100	Each	3.0000	1	B100304 - 7
			Location	Loc Oty		Loc Code		B100304-7
						<u> </u>		<u> </u>
								
				2				
	Manufactured	No	7/710	100	Each	4.0000	2	2 (P(13.6.4) B100857
							C. I	(15.0)
			Location	Loc Qty	•	Loc Code		B10085= ~
			WA004	2				
			100358	1				
			97938	l				
			WA005	2				
			81444	2				
	Manufactured	No		100	Each	10.0000	3	3 CpC 13.6.4 \$100439->
			Location	Loc Oty		Loc Code		3/00439-
	•		WA004	5				
				and the second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second second s				
				3				
				5		4		•
				1				•
			82933	4				
	D3913-041	D3913-041 Long Basket Base Assemby, 350 Manufactured Manufactured Manufactured	D3913-041 Long Basket Base Assemby, 350 Manufactured No Manufactured No Manufactured No	Long Basket Base Assemby, 350 No	Long Basket Base Assemby, 350 100 100	D3913-041	No	Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digital Digi

			DQA:	Date:	
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			
			OA Classel	Data	

											QA Closed:	Dat	te:		
Work Orde	er: _					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework Skid-tube Crosstube Water Jet Machining Small Fab Prod. Eng. Coor. Thermoforming Finishing Rec/Store/Packaging Supplier									Quality Other					
Root					Descri	ption of work order update	Ī	nitial	Ad	ction	Sign &				
Cause	Ì	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	n QC Inspector		
Doc/Data										•					
Equip/Tooling						•	l								
Operator -															
Material															
Setup							1								
Other															
Process				ļ	·					·					
Supplier		i													
Training															
Unapproved															
						F.	AUL	T CATE	GORY						
Landi	ng G	Gear				General				_	-				
		Bending				Bend	\vdash	Grain			Ovalized		Pressure/Forced		
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure		
'		Cracks			_	Broken/Damaged		Inspecti	ion Incomplete		Part Incorred	ct	Weld		
		Crushed/0	Crimped		<u> </u>	Burrs	Ш		ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
	Ш	Cuffs				Contamination	\sqcup	Mainte			Part Moved				
	Ш	Heat Trea	it			Countersink		Mislabe	eled		Positioned V	· ·			
		Inspection	-	Tube		Cut Too Short		Misread	t		Power Loss/	Surge	Other		
		Ripples in	Bend		L	Drill Holes		Offset							
		Torque W	aves in E	xtrusio	n _	Drawing	Ŀ	Out of (Calibration			· .	<u> </u>		
		Turning S	equence			Finish		Out of S	Sequence			<u>.</u>			
		Wave/Tw	ist in Tub	oe .		Folio		Outside	Dimensions						

Work Order ID:	102109						
Parent Item:	D3913-041				Start	Date: 5/27/13	Required Date: 6/05/13
Parent Item Name:	Long Basket Base Assemby, 350				Start	Qty: 1.00	Required Qty: 1.00
D4016-1 Hinge Half, Base	Manufactured	No	100	Each	46.0000	3	3 CpL13.6.4
	e e	Location	Loc Qty		Loc Code	3944	81 -> (3)
		WA	4	;	•		
			27664				
		WA004	30				
		,	00265 30				
	•	WA005	11				
			94481			-	_
D4017-7 Rib	Manufactured	No	100	Each	15.0000	1	1 PC12.6.4 3100413
		Location	Loc Qty		Loc Code		B160413->
		WA004	•				
			94149				_ _
		WA005	14	ļ.			•
			100413				 -
,			59730			-	
	•	8	32969				
		8	35435				
		8	38392				
D4017-9 Rib	Manufactured	No	100	Each	15.0000	2	2 (pc 13.64)
		Location	Loc Oty		Loc Code	3	B100537-
		WA004	12	2			
		1	100537	2			
		WA005		3			
			70341				
			31445			 	<u> </u>

DQA:	Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

		•						•		QA Closed:	Dat	e:
Work Orde	r.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap		ı	Skid-tube Machining	Crosstube Small Fab	-	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	lo				Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	re/Packaging Supplier	Other
Root				Descri	ption of work order update	In	itial	Ad	ction	Sign &		
Cause	Date	Step	Qty	į	or Non-conformance	Chie	ef Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling						1						
Operator -												
Material						1				ľ		
Setup	,	,										
Other												
Process						ļ						
Supplier												
Training												
Unapproved												
					F/	AULT	CATE	GORY				
Landir	ng Gear				General						-	
	Bending				Bend	\Box	Grain			Ovalized	Γ	Pressure/Forced
	Centre No	ot Conce	ntric to (o/s	BOM/Route	I,	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Πı	nspecti	on incomplete		Part Incorred	ct [Weld
<i>'</i>	Crushed/	Crimped			Burrs	П	nstruct	ions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs	-			Contamination	Пı	Mainte	nance		Part Moved	_	<u> </u>
	Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong	
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/:	Surge [Other
	Ripples in				Drill Holes	П	Offset		•	-		
	Torque V		Extrusio	n	Drawing	-		Calibration				
	Turning S				Finish	-		Sequence				
	Wave/Tw				Folio	\blacksquare		Dimensions				

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o Work Order ID:	102109								
Parent Item:	D3913-041						Start	Date: 5/27/13	Required Date: 6/05/13
Parent Item Name:	Long Basket Base	Assemby, 350					Star	t Qty: 1.00	Required Qty: 1.00
D4020-11 End Mesh, Basket		Manufactured	No		100	Each	7.0000	2	2 Cpc 13.6.4
				Location	Loc Qty		Loc Code		B100650 -> (3)
	•			WA007	7				
				100650	4				
				81442	2				
				84972	1				<u> </u>
D4021-1 Handle Plate		Manufactured	No		100	Each	75.0000	3	3 (pc13.6.4) 3 (pc13.6.4)
				<u>Location</u>	Loc Oty		Loc Code		B100649-3
		•		WA004	. 75				
				100366	54				
				100649	16				
				94596	3				
				97940	2				<i>2</i> 2
D4021-5 Blanking Plate		Manufactured	No	100 249.	150	Each	8.0000	2	2 ft Bl 136-5.
				Location	Loc Qty		Loc Code		
				ST084	8				
				85065	2				
				98260	. 6				
D4034-041 Aft Upper Rib Assembly	v	Manufactured	No		100	Each	6.0000	1	1 (13.6.4
орраг гас гасаног,	,			Location	Loc Oty		Loc Code		B94977 - (1)
				WA004	2				_
				94813	- 1				<u></u>
				94977	1				<u></u>
				WA005	4				
	•			100301	3				
				84048	1				
	•			·					

NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UPDAT	ΓE			
											QA Closed:	Date:	
Work Ord	er:					DISPOSITION			•	AGAINST DE	PARTMENT	/PROCESS	
Part I	-	< N . ·		٠.		Rework Scrap Use-as-is Work Order Update	Therm	Machining S noforming	Finishing omposite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root						ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Description	on	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator ~ Material Setup Other Process Supplier Training Unapproved													
		· · · · · · · · · · · · · · · · · · ·				F	AUI	LT CATE	GORY				•
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio	Crimped at n Strip in		D/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misread	on Incomplete ions Incomplete/Uncle nance led	ear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
1	Ripples in Bend				1	Drill Holes	-	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Work Order ID: Parent Item:	102109 D3913-041			•			Start Γ	Date: 5/27/13	Required Date: 6/05/13
Parent Item Name:	Long Basket Base	Assemby, 350						Qty: 1.00	Required Qty: 1.00
D4034-043 Fwd Upper Rib Assembl	ly	Manufactured	No		100	Each	6.0000	1	1 (d13.6.4
				Location	Loc Qty		Loc Code		B100288-
				WA004	1				3,1000/00 - Silve
				100286	1				
				WA005	5			•	
				100288	3				
				82980	2				
94672-1 Blanking Plate		Manufactured	No		100	Each	18.0000	2	2 6113.6.4.
				Location	Loc Oty		Loc Code		B101186 7
				WA004	14				
				101186	14				·
				WA005	4				
				88253	4				— <i>′</i> 2
1304EX0.75-16F Expanded Metal Flat SS		Purchased	No	,	100	sf	1,289.8151	33	33 Cpl 13.6.4
				Location	Loc Oty		Loc Code		m125457-
				MAT	176.2791180				
		•		125113	176.279118				
				WA	414		÷		
				125457	414				
				WA007	699.536				
				123448	15.96				<u> </u>
				125457	203.576				
				125605	480				<u> </u>

											DQA:	Dat	te:			
NCR:	Yes	/ No				WORK ORDER NON	-COI	NFORM	AANCE / UP	DATE						
								<u> </u>			QA Closed:	Dat	:e:			
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part f	No.					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			-4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
	•			,					·	· <u> </u>						
Root		Data	Chan	0	Desc	ription of work order update	í	Initial		tion	Sign &	Verification	OC Inspector			
Cause	Γ.	Date	Step	Qty		or Non-conformance	- Cr	ief Eng	Desc	cription	Date	vernication	QC Inspector			
oc/Data quip/Tooling perator		,														
laterial		į	٠.										,			
etup	\vdash							i								
ther	-															
rocess	<u> </u>															
upplier																
raining	<u> </u>															
napproved	<u> </u>	L	<u> </u>				FAUI	T CATE	GORY		1					
Landi	ng (General										
	_	Bending			Γ	Bend		Grain			Ovalized	Γ	Pressure/Forced			
		Centre No	ot Concer	ntric to (o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure			
		Cracks			Γ	Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct [Weld			
		Crushed/0	Crimped			Burrs		Instruct	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
		Cuffs				Contamination		Mainte	nance		Part Moved	_				
		Heat Trea	it			Countersink		Mislabe	led		Positioned V	Vrong _				
		Inspection	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other			
		Ripples in	Bend			Drill Holes		Offset								
		Torque W	aves in E	Extrusio	า [Drawing		Out of C	Calibration				·			
		Turning S	anuanca		Г	Finish		Out of S	equence							

Outside Dimensions

Wave/Twist in Tube

Folio

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Picklist Print

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Page 7

Work Order ID: Parent Item: Parent Item Name:	102109 D3913-041 Long Basket Base Assemby, 350					Pate: 5/27/13 Qty: 1.00		Required Date: 6/05/13 Required Qty: 1.00
MS20600-AD4W3 Cherry Rivets	Purchased	No	150	Each	1,119.0000	2	2	pl 13-6-5.
		Location	Loc Oty		Loc Code			***
		ST311	- 986					
		12215						
		12245						
		12352						
		12423	•			_	· ·	
		WA003	133					
		10793						· '
MS21042L3 Nut	Purchased	No	150	Each	3,253.0000	6	6	bl 13-65
		Location	Loc Qty		Loc Code			
		FP001	3					
		12214	1 3					
		GA	18					
		12245	2 18					•
		ST314	268					-
		11788						
		11901						
		11907						
		12326				•		
		ST506	2964					

954 2010

123900 124291

											DQA:	U	ate.		
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFOR	MANCE / UPDATE		QA Closed:		ate:		
						DISPOSITION			AGAIN	ST DE			atc.		
Work Ord	er:					DISPOSITION	_		AGAINST DEPARTMENT/PROCESS						
						Rework		Skid-tube Crosstube			Water Je	tL	Engineering		
Part	No.		· · · · · · · · · · · · · · · · · · ·			Scrap		l .	Machining Small F	_	-	d. Eng. Coor	_	Quality	
						Use-as-is		Thern	noforming Finishi		Rec/Sto	e/Packaging	-	Other	
NCR	No.					Work Order Update	_		Large Fab Composi	te		Supplie	rL		
Root					Descr	iption of work order update	T	Initial	Action		Sign &				
Cause		Date	Step	Qty		or Non-conformance	C	hief Eng	Description		Date	Verification	on	QC Inspector	
Doc/Data	ľ														
Equip/Tooling															
Operator			İ												
Material															
Setup			ļ											•	
Other				ļ											
Process															
Supplier															
Training		•				,	-						1		
Unapproved			<u> </u>								<u> </u>				
							AU	LT CATE	GORY						
Land	_	Ī				General		7		£	٦			1 .	
		Bending			, 	Bend	<u> </u>	Grain		\vdash	Ovalized			Pressure/Forced	
	<u></u>	Centre N	ot Conce	ntric to	o/s	BOM/Route	-	Hardwa		\vdash	Over/Under tolerance Part Incorrect			Temperature/Cure	
	Cracks Broken/Damaged				⊣ ` •	_	⊣ `	ŧ' ' ⊢				Weld			
1]	Crushed/	Crimped		Burrs				ions Incomplete/Unclear	- 1	Part Lost/Missing			Wrong Stock Pulled	

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

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Work Order ID:

102109

Parent Item:

NAS1149F0332P

WASHER

D3913-041

Parent Item Name:

Long Basket Base Assemby, 350

Purchased

No

Start Date: 5/27/13

Required Date: 6/05/13

Start Qty: 1.00

Required Qty: 1.00

12,498.000 12 12 H 136-5.

Location	<u>1</u>	Loc Qty	Loc Code		
GA		182			
	122063	182			
ST294		158			
	122063	158			
ST295		3			
	123352	3			
st510	/	7155			•
	123900	7155		_/2	
ST510a		5000			
	125646	5000			

150

Each

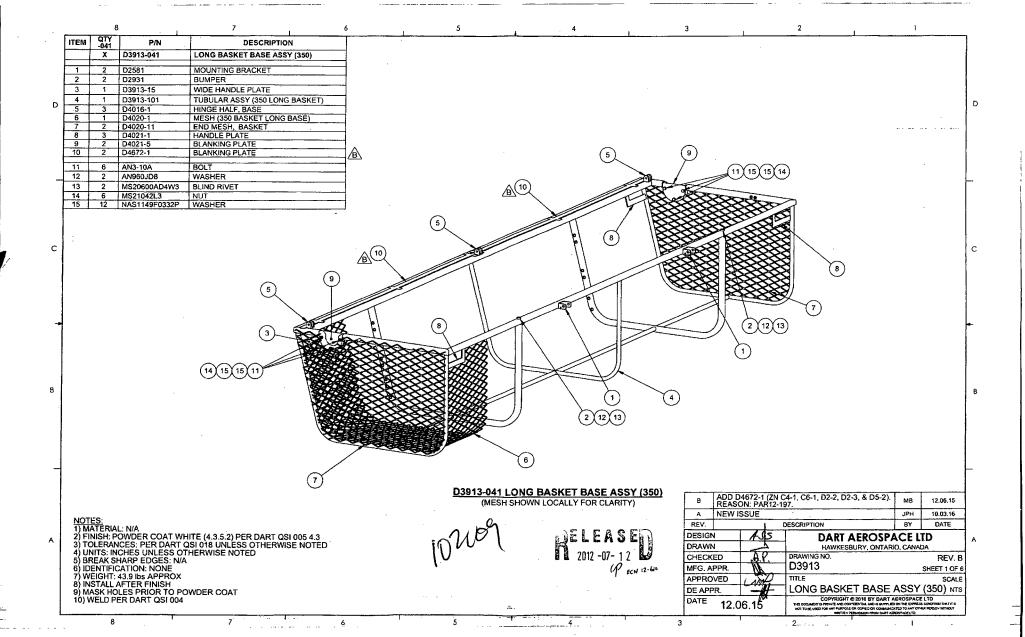
												DQA:	Dat	te:	
NCR:	⁄es	/ No					WORK ORDER NON-C	100	NFOR	MANCE / UPDA	TE	OA Classide		.	
						_						QA Closed:	Dat	te:	
Vork Orde	er:					Ì	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N	•						Rework Scrap		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			Water Jet Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Other
NCR N	lo.						Use-as-is Work Order Update		mem	~ —	omposite	Nec/3tol	Supplier		Other
Root					Desc	rip	tion of work order update	I	nitial	Action		Sign &			
Cause		Date	Step	Qty		O	r Non-conformance	Ch	ief Eng	Descripti	ion	Date	Verification	n_	QC Inspector
oc/Data															
quip/Tooling								İ							
perator															
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etup								l							
ther		:				•		1							
rocess															
upplier															
raining			i												
napproved															
							,	AUL	T CATE	GORY					
Landi	ng (1					General		1		_	7	r		İ
		Bending					Bend	<u> </u>	Grain			Ovalized	,		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	_	BOM/Route	<u> </u>	Hardwa	-	ļ	Over/Under			Temperature/Cure
		Cracks			}		Broken/Damaged	<u> </u>	1	on Incomplete		Part Incorred		\vdash	Weld
	L	Crushed/0	Crimped		1		Burrs	<u> </u>	4	ions Incomplete/Uncl	ear	Part Lost/Mi	ssing		Wrong Stock Pulled
	_	Cuffs			1		Contamination	<u> </u>	Mainte			Part Moved	*		
	L	Heat Trea				Countersink			Mislabe			Positioned W		_	
	_	Inspection		Tube	ļ	Cut Too Short			Misread	I		Power Loss/	Surge		Other
	<u> </u>	Ripples in	Bend		ļ	Drill Holes			Offset						
	L	Torque W	Vaves in Extrusion Drawing					4	Calibration			,			
		Turning S	equence			Finish				Sequence					

Outside Dimensions

Wave/Twist in Tube

Folio

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												DQA:	Da	ate:	
NCR:	⁄es	/ No				WORK ORDER NON-O	100	NFOR	MANCE / UPI	DATE		·			<u> </u>
												QA Closed:	Da	ite:	
Work Orde	er:					DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
Part No						Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Prod. Eng. Co Rec/Store/Packag				Engineering Quality Other	
Root					Descri	ption of work order update		nitial	Act	tion	T	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription		Date	Verificatio	n	QC Inspector
Doc/Data							1				1				
Equip/Tooling															
Operator											ı				
Material			:								Ì				
Setup															
Other															
Process					i		l								
Supplier							ł								
Training															
Unapproved															
						F	AUL	T CATE	GORY						
Landi	ng (ear				General		_						_	-
		Bending				Bend		Grain				Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance	L	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	ion Incomplete			Part Incorrec	t		Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/U	Jnclear =]	Part Lost/Mis	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		٦	Part Moved			-
		Heat Trea	t			Countersink		Mislabe	led		٦	Positioned W	/rong	_	_
	Inspection Strip in Tube Cut Too Short					Misread	ţ	Power Loss/S	Surge		Other				

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

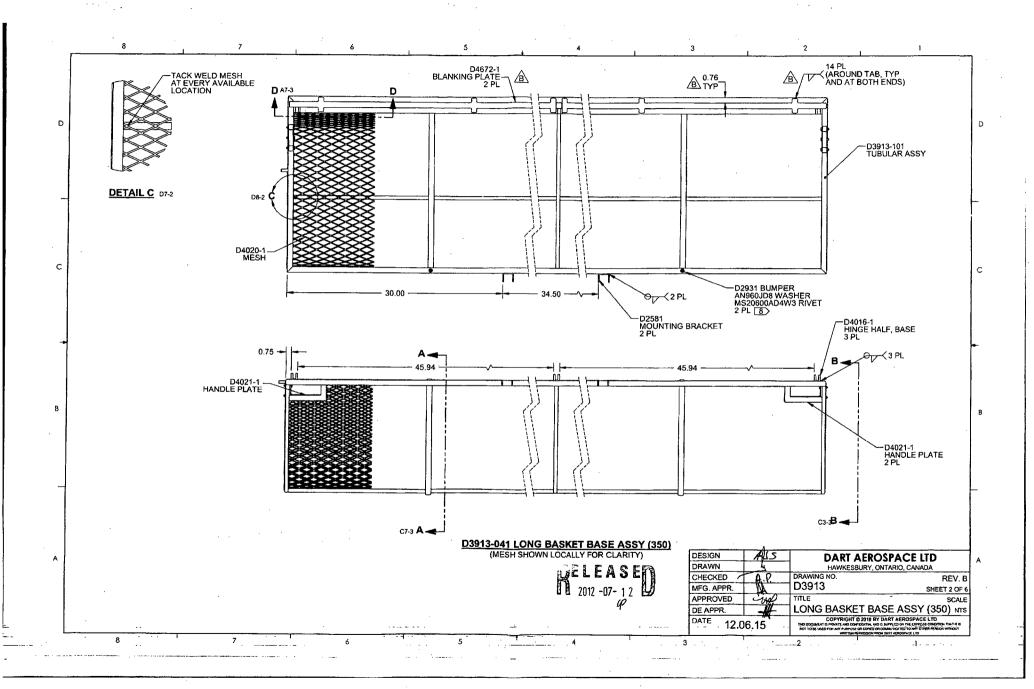
Torque Waves in Extrusion

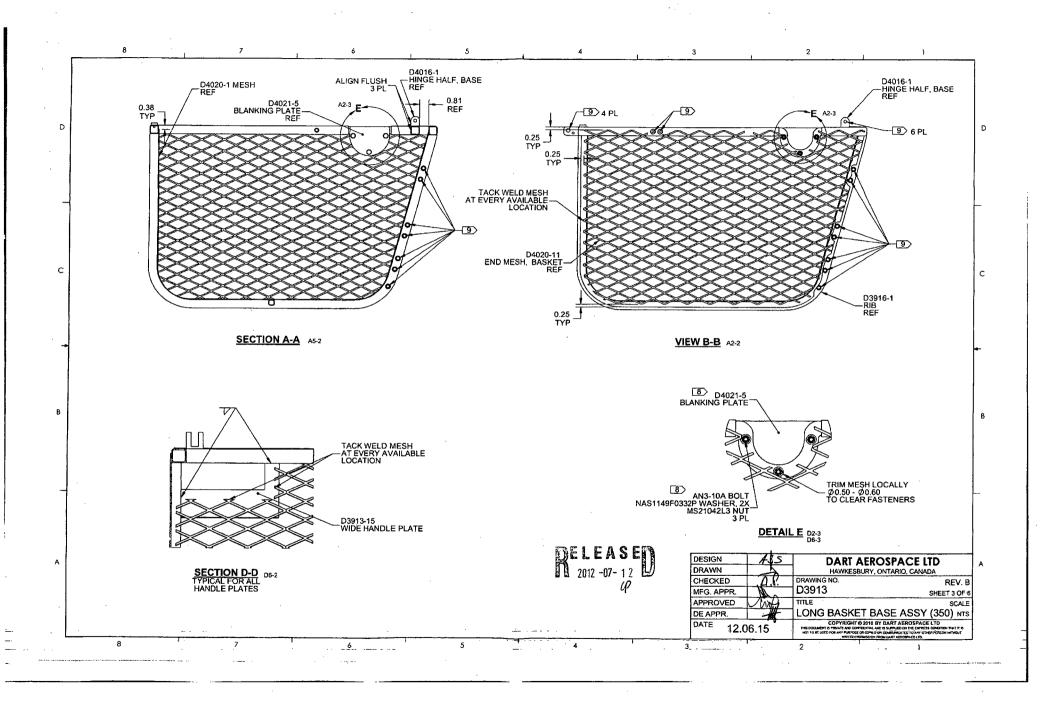
Drill Holes

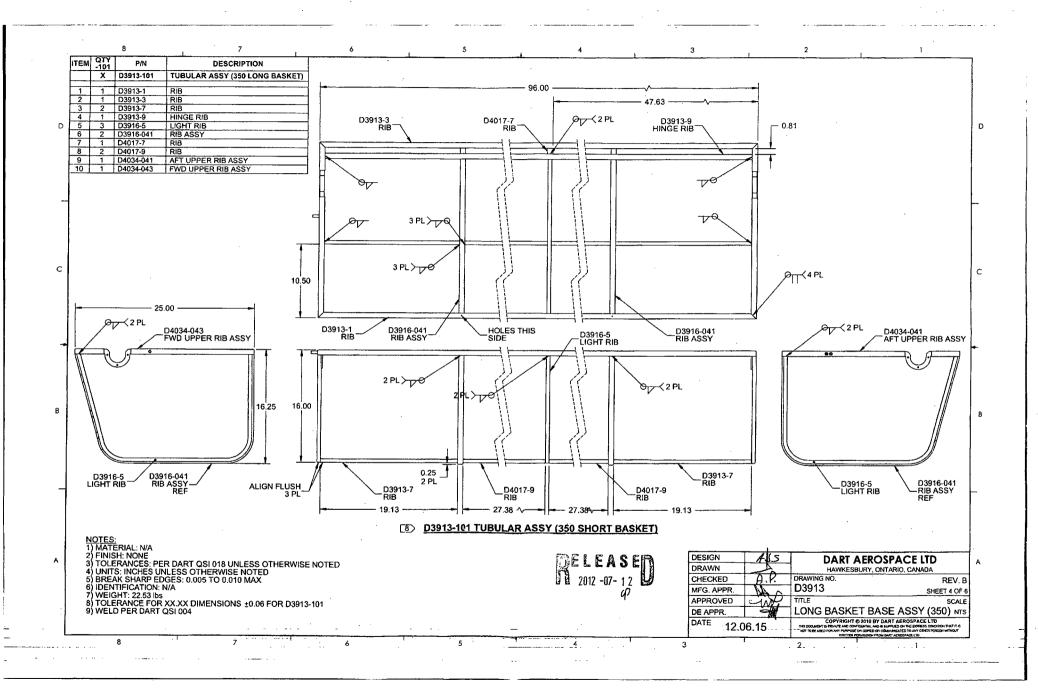
Drawing

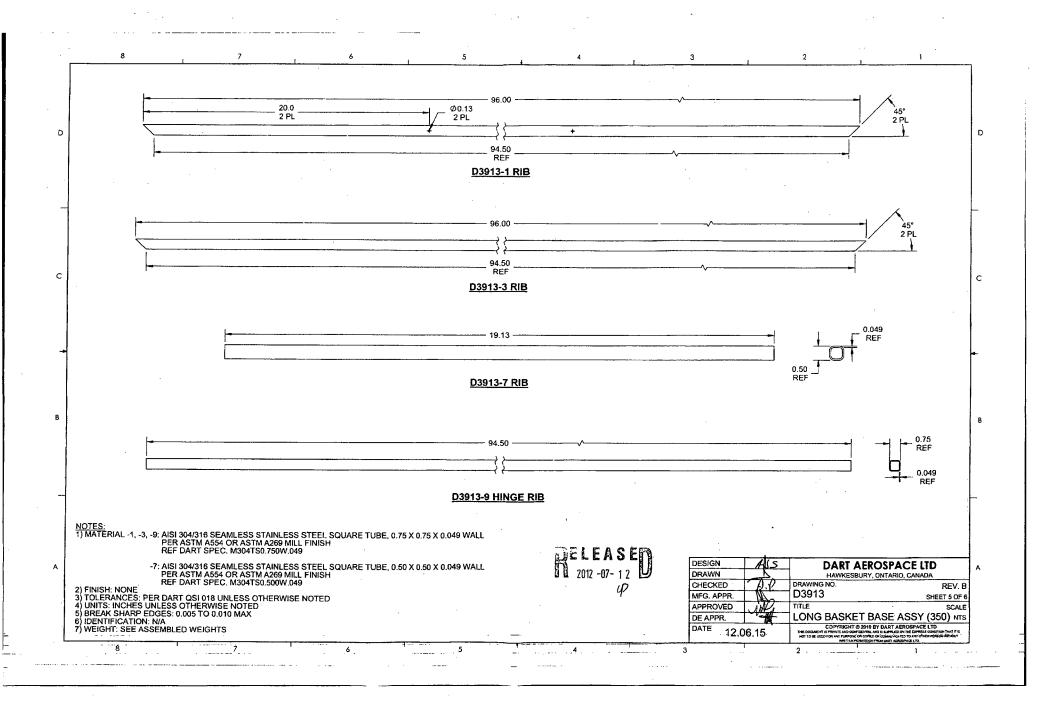
Finish

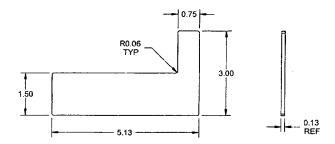
Folio











D3913-15 WIDE HANDLE PLATE

NOTES:
1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.31 lbs

8

	1	
DESIGN	1.5	DART AEROSPACE LTD
DRAWN	1 5	HAWKESBURY, ONTARIO, CANADA
CHECKED	A.V.	DRAWING NO. REV. B
MFG. APPR,	M	D3913 SHEET 6 OF 6
APPROVED	100	TITLE SCALE
DE APPR.	4	LONG BASKET BASE ASSY (350) NTS
DATE . 12.0	06.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROVIDE AND COMPORTING AND CONTROL OF THE DIFFEST COMPONENT HATTER IS NOT TO BE USED FOR ANY PURPOSE OF COMPONENT HATTER PRESENT HITCH FOR ANY OTHER PRESENT HITCH FOR THE PURPOSE AND ANY SPECIAL TO